

Work Order ID 54877

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Page 1

Item ID: D3686-041

Accept

Revision ID:

Item Name: MONOPOD ASSEMBLY

Start Date: 1/5/2010 Start Qty: 1.00

Required Date: 1/25/2010 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: *mf*

Date: 10-01-04 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3686

Rev C

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

SB 12/01/25

(2)

110

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-Use anti-seize compound Tectly 502c Class 1, Mil-PRF-16173E or equivalent on thread and assemble as per dwg D3686

2-Assemble D3693-1 & D3691-1 & D3693-3 & D3688-7 Using Sikaflex -241/-291 between mating surfaces as per Dwg D3686

***Ensure holes for AN3C Bolts are free of sealant.

Torque Fastners as per Dwg D3686

SB 12/01/25

(2)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Item ID: D3686-041

Accept



Setup Start



Revision ID:

Stop



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Start Date: 1/5/2010 Start Qty: 1.00



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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

⇒ 8060125

(X2)

130

Identify as per dwg & Stock Location: 19

0.00



Packaging

Memo

0.00

Packaging

10-1-25 (2459)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/26

MF 10-1-25

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Work Order ID: 54877

Parent Item: D3686-041

Parent Item Name: MONOPOD ASSEMBLY



Start Date: 1/5/2010

Required Date: 1/25/2010

Comments:

Start Qty: 1.00

Required Qty: 1.00



Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3688-7		Manufactured	No			110	Each	15.0000	1.0000			
												
STUD												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	15	
44686	1	
46055	5	
46699	2	
50931	7	

3
2
3
SB 10/01/25



D3689-1		Manufactured	No			110	Each	21.0000	1.0000			
												
SLEEVE												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	2	
46051	2	
Main Warehouse		
ST125	19	
50745	19	

2
SB 10/01/25

D3691-1		Manufactured	No			110	Each	0.0000	1.0000			
												
STUD												

B 54859

SB 10/01/25

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Start Date: 1/5/2010

Required Date: 1/25/2010

Comments:

Start Qty: 1.00

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3692-1		Manufactured	No			110	Each	642.0000	4.0000			
												
SPACER												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 55

44827 8

45672 14



50325 33

Main Warehouse

ST127 587

50736 179

51467 408

D3692-3		Manufactured	No			110	Each	57.0000	4.0000			
												
SPACER												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 57

44690 57

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Comments:

Start Date: 1/5/2010

Required Date: 1/25/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3693-1		Manufactured	No			110	Each	73.0000	1.0000			
												
Rod End Bearing												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

5

45723

5

Main Warehouse

ST127

68

50733

7

50734

61

D3693-3

Manufactured No

110

Each

13.0000

1.0000



Rod End Bearing



Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

6

45724

1

50723

5

Main Warehouse

ST127

7

50723

7

SB 10/01/25

2

2 SB 10/01/25

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Start Date: 1/5/2010

Required Date: 1/25/2010

Comments:



Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C10A  Bolt		Purchased	No			110	Each	66.0000	2.0000 			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	66	
102116	7	
105940	39	
112489	20	

4 88 10/01/25

AN3C12A  Bolts		Purchased	No			110	Each	350.0000	2.0000 			
--	--	-----------	----	--	--	-----	------	----------	---	--	--	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	350	
112314	350	

4 88 10/01/25

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Start Date: 1/5/2010

Required Date: 1/25/2010

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS21043-3

Purchased

No

110

Each

4,542.000

4.0000



Nut

Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

FG

80

103691

80

Main Warehouse

ST

4462

111819

70

112243

29

112314

4363

80 10/01/25

8

NAS509L12C

Purchased

No

110

Each

85.0000

1.0000



Nuts

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

85

106993

2

112314

73

112828

10

80 10/01/25

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Comments:

Start Qty: 1.00

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS509-12C 		Purchased	No			110	Each	126.0000	1.0000			
Nuts												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	126	
106993	7	
110844	10	
112453	109	

2

SS 10/01/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

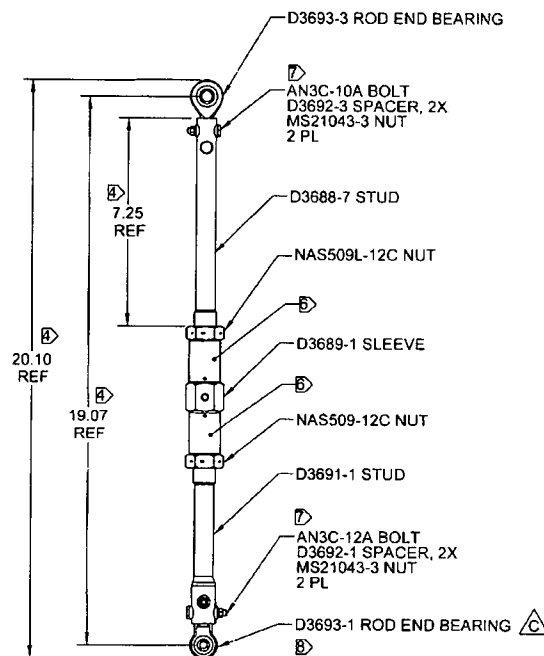
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ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D3686-041	MONOPOD ASSEMBLY
2	1	D3688-7	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	4	D3692-3	SPACER
7	1	D3693-1	ROD END BEARING
8	1	D3693-3	ROD END BEARING
9	2	AN3C-10A	BOLT
10	2	AN3C-12A	BOLT
11	4	MS21043-3	NUT
12	1	NAS509L-12C	NUT
13	1	NAS509-12C	NUT



D3686-041 MONOPOD ASSEMBLY

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3686-041 USING FINE POINT PERMANENT INK MARKER
- 4) DIMENSIONS SHOWN ARE WHEN D3688-7 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 3.0 lbs
- 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 & D3693-3 WITH D3688-7 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

C	ROD END BEARINGS NOW ASSEMBLED USING SEALANT (ZN A8-1, B4-1)	RF	08.12.15
B	REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.05.22
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3686	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		MONOPOD ASSEMBLY	NTS
DATE	08.12.15	COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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